

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013177**Date Inspected:** 12-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as 7BE+7CE LD hold back welds. The weld designations reviewed are as follows:

1. SEG036C-043, 041
2. SEG038B-043, 047
3. SEG038C-030
4. SEG036C-047
5. SEG038B-008

7DE

Shield Metal Arc Welding (SMAW) VT repair welding was performed on side plate t stiffeners located on cross beam side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G

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(2F)-Repair-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007 and 008 located at DP665-001 counter weight of segment. Welder is identified as Mr. Du Hengyou (037743). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-4114-1.

7CE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 013 and 014 located at DP664-001 counter weight of segment. Welder is identified as Mr. Du Hengyou (037743). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-4114-1.

7EE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at CA046 cross beam side of segment. Welder is identified as Mr. Fang Huajun (066258). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1379 repair procedure

Y Location of repairs areas by above noted welder (066258) is located at 9000~1050mm.

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA042 bike path side of segment. Welder is identified as Mr. Sun Lingling (048047). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1378 repair procedure.

Y Location of repairs areas by above noted welder (048047) is located at 6890 and 7030mm.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions at Tail Assembly Yard. Locations and description of work are as followed:

7CE+7DE

1. Back gouging was performed on the edge plate weld splice located on the bike path side of segment.

8AE

1. Edge plate edge located on the bike path side of segment being trimmed with a mechanical guided torch.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
Reviewed By:	Miller, Mark	QA Reviewer
